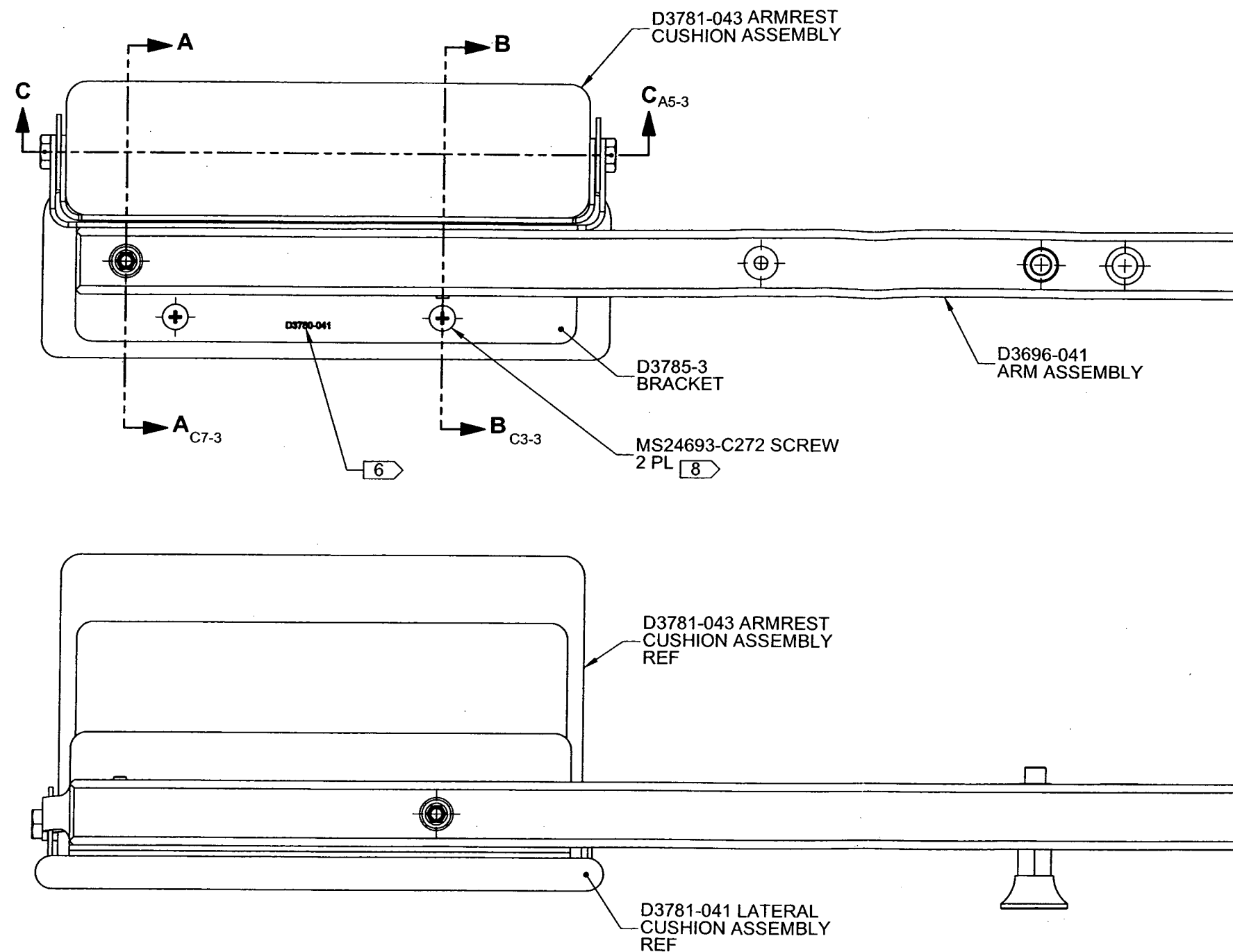


PRELIMINARY ISSUE
FOR OT. 11

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	09.05.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

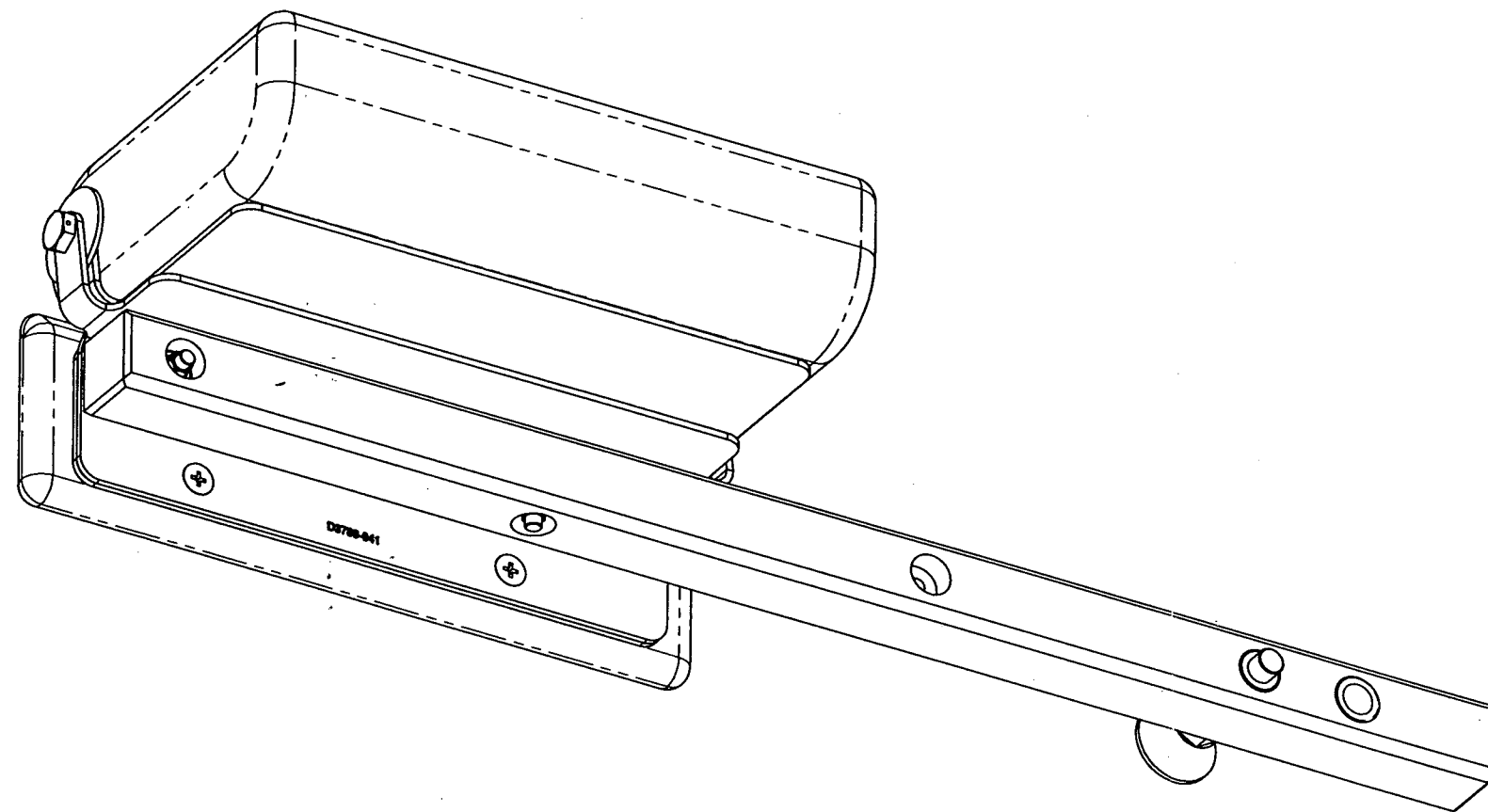


D3780-041 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3780-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 2.89 lbs
- 8) TORQUE BOLTS TO 20-25 in-lb.
- 9) LOCK WIRE AN4H10A BOLTS TO D3585-3 BRACKET

PRELIMINARY ISSUE
2009.05.11

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ADS	DRAWING NO. D3780	REV. D
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE ARMREST ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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D3780-041 ARMREST ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041 /	ARM ASSEMBLY 1746201
4	1	D3781-041 /	LATERAL CUSHION ASSEMBLY 174940
5	1	D3781-043 /	ARMREST CUSHION BASE ASSY 1746436
6	1	D3785-3 /	BRACKET 174944
11	2	AN4H10A	BOLT 1111975
12	2	AN960JD10L /	WASHER 1169637
13	2	AN970-4	WASHER 1112087
14	A/R	MS20995-C41	LOCK WIRE N/A THIS W/O.
15	2	MS21042L3 /	NUT 1111274
16	2	MS24693-C272 /	SCREW 118815
17	2	MS24693-C277 /	SCREW 1109292

PRELIMINARY ISSUE

10.05.11

D	REDESIGNED BASED FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.11
C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	MD	D3780	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	09.05.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

D3781-041 LATERAL
CUSHION ASSEMBLY
REF

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

MS21042L3
NUT
AN960JD10L
WASHER
MS24693-C272
SCREW
MS24693-C277
SCREW

SECTION A-A C7-2

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

MS24693-C277
SCREW

D3781-041 LATERAL
CUSHION ASSEMBLY
REF

D3785-3
BRACKET
REF
AN960JD10L
WASHER
MS21042L3
NUT
MS24693-C272
SCREW

SECTION B-B C6-2

AN970-6 WASHER
2 PL

NAS1149D0663J
WASHER

D3978-1 NUT (CASTELLATED), UNC
MS24665-302 COTTER PIN 8

D3785-3 BRACKET
REF

D3977-1 BOLT (CARRIAGE), UNC

D3781-043 ARMREST
CUSHION ASSEMBLY
REF

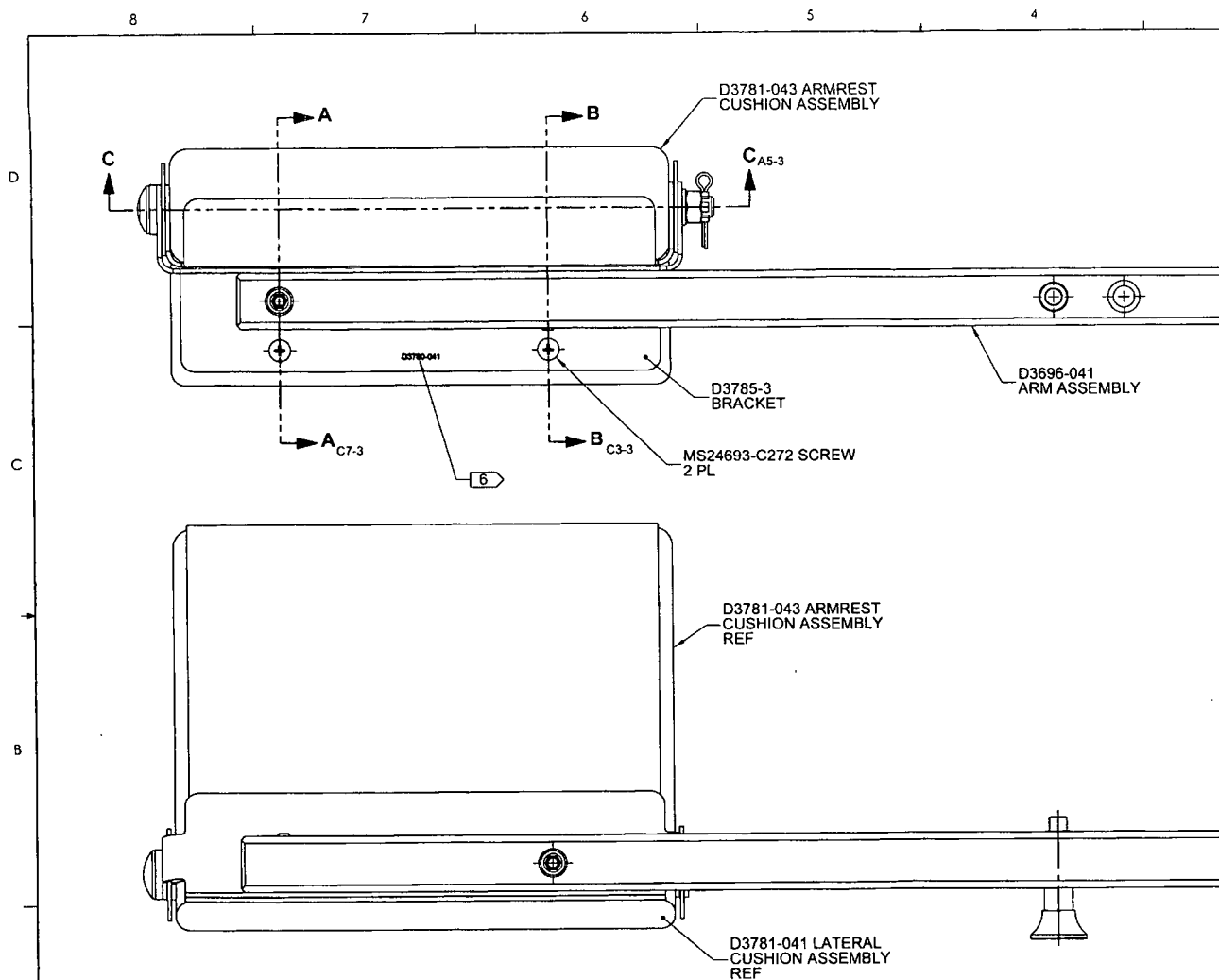
D3979-1 WASHER (SQUARE HOLE)

SECTION C-C D5-2
SCALE: 2X

48675

RELEASED
07/04/11

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	09.05.11	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3780-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3780-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 3.71 lbs
- 8) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540 OR AC43.13 CHAPTER 7-127

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3780	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	09.05.11	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

RELEASED
27/07/14

48675

8

7

6

5

4

3

2

1

8

7

6

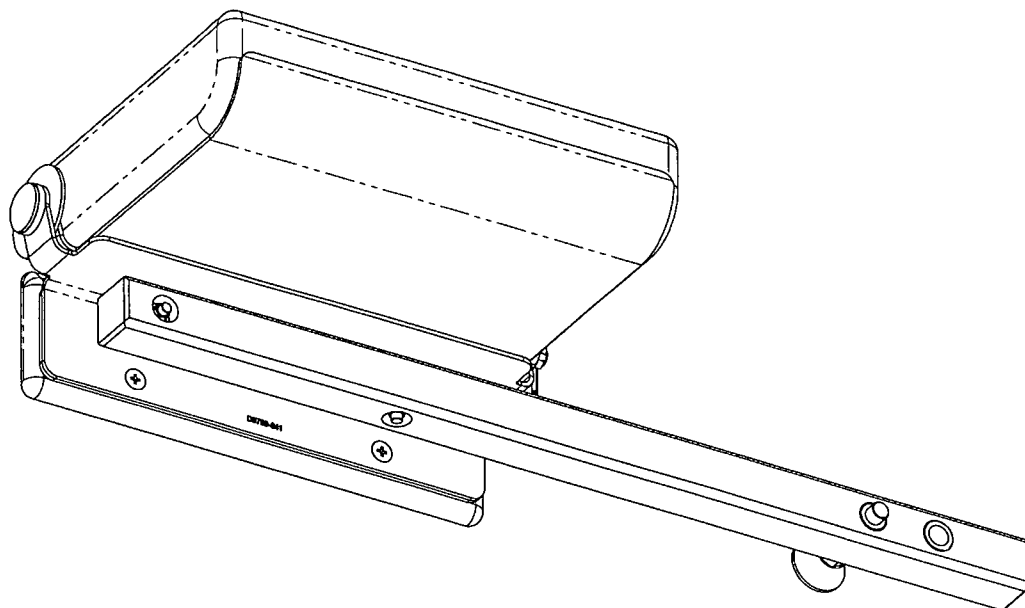
5

4

3

2

1



D3780-041 ARMREST ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3780-041	ARMREST ASSEMBLY
3	1	D3696-041	ARM ASSEMBLY
4	1	D3781-041	LATERAL CUSHION ASSEMBLY
5	1	D3781-043	ARMREST CUSHION BASE ASSY
6	1	D3785-3	BRACKET
7	1	D3977-1	BOLT (CARRIAGE), UNC
8	1	D3978-1	NUT (CASTELLATED), UNC
9	1	D3979-1	WASHER (SQUARE HOLE)
12	2	AN960JD10L	WASHER
13	2	AN970-6	WASHER
14	2	MS21042L3	NUT
15	1	MS24665-302	COTTER PIN
16	2	MS24693-C272	SCREW
17	2	MS24693-C277	SCREW
18	1	NAS1149D0663J	WASHER

RELEASED
07/07/11

D	REDESIGNED BASED FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.11
C	UPDATED BOM TO CURRENT STANDARDS; REDESIGNED ITEM 4. REASON: COMPATIBILITY WITH 204 SEATS	MB	08.11.03
B	REDESIGNED TO ELIMINATE FWD/AFT ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN	1/1		
DRAWN	1/1		
CHECKED	1/1		
MFG. APPR.	1/1		
APPROVED	1/1		
DE APPR.	1/1		
DATE	09.05.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3780		REV. D	
TITLE ARMREST ASSEMBLY		SCALE	
NTS			
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48675

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 1:01:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMREST ASSEMBLY

Job Number: 48675

Part Number: D3780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS24693C272

Screw



2.000

2.000



Comment: Qty.: ~~5.0000~~ Each(s)/Unit Total : ~~5.0000~~ Each(s)

Screw

batch: 18815 12.06.22 (2)

7.0

MS24693C277

Screw



2.000

2.000



Comment: Qty.: ~~3.0000~~ Each(s)/Unit Total : ~~3.0000~~ Each(s)

Screw

batch: 1109297 12.06.22 (2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D3780

****torque screws as per dwg D3780****

REV. D

PRELIM DATED 09.05.11

9.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker as per dwg (see note 6) and Stock

Location: _____

FOR ENG. USE ONLY. 12.06.22

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



002244

POSITIVE RECALL

EFFECTIVE _____

RELEASED _____

AUTH _____

DATE _____

FOR ENG. USE ONLY!

12.06.23

W/		WORK ORDER CHANGES						
-DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
04.06.22	2.5	ADD: PULL D3781-043 ARREST CUSHION ASSY, QTY. 1 BATCH: <u>B48436</u> 1304.06.22				↓ 04.06.22		
04.06.22	3.5	ADD: PULL AN4H10A BOLT, QTY. 2 BATCH: <u>M111935</u> 1304.06.22				↓ 04.06.22		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
04.06.22	4.5	WORK ORDER CHANGE ADD: PULL AN970-4 WASHER, QTY. 2 BATCH: <u>M112082</u> 1304.06.22	N/A	N/A	N/A	N/A	↓ 04.06.22	

NOTE: Date & initial all entries

Date: Monday, 22/06/2009 1:01:59 PM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARMREST ASSEMBLY
Job Number : 48675
Estimate Number : 13346
P.O. Number :
This Issue : 22/06/2009 S.O. No. :
Prsht Rev. : NC Part Number : D3780041
First Issue : 11 Type : SMALL /MED FAB Drawing Number : D3780 **REV. D PRELIM**
Previous Run : 46027 Drawing Revision : **DATED 09.05.11**
Material :
Due Date : 29/06/2009 Qty: 1 Um: Each
Written By :
Checked & Approved By : MF 09-06-22
Comment : Est Rev:A 08-05-26 new issue DD verified by:ec
Est Rev:B 08-07-22 revB as per dwg verified by:EC
Est Rev:C 09-01-08 rev.C as per dwg DD verified by:ec



Additional Product

PRELIMINARY ISSUE

Job Number:



09.06.22

Seq. #: Machine Or Operation: Description :

1.0 D3696041 Arm Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Tube Assembly
batch: B46201 09.06.22 ① →

Not applicable on this w/o only
RETURNED TO STOCK 09.06.23

2.0 D3781041 Lateral Cushion Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cushion Assembly
batch: B47992 09.06.22 ①



3.0 D37853 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket
batch: B47994 09.06.22 ①



4.0 AN96010L Washer



Comment: Qty.: ~~3.0000~~ 2.000 Each(s)/Unit Total : ~~3.0000~~ 2.000 Each(s)
Washer
batch: 1109672 09.06.22 ②



5.0 MS21042L3 Nut



Comment: Qty.: ~~3.0000~~ 2.000 Each(s)/Unit Total : ~~3.0000~~ 2.000 Each(s)
Nut
batch: H111274 09.06.22 ②

